

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-028857**Date Inspected:** 13-Dec-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Andrew Keech**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS Tower**Summary of Items Observed:**

Caltrans Office of Structural Material (OSM) Quality Assurance Inspector (QAI) Joselito Lizardo was present at the Self Anchored Suspension (SAS) job site as requested to perform observations on the welding of components for the San Francisco Oakland Bay Bridge (SFOBB) Project.

At Tower Base Electro Slag Weld (ESW) 'G' weld joint #S-045 face B, ABF personnel was observed continuing to perform exploratory excavation on welded ESW at location Y=8030mm due to UT detected defect. The ABF personnel have resumed the exploratory excavation from 19mm deep where fellow QA William Clifford has turned over the observations due to other assignment at Pier 7. The personnel were noted using only the disc grinder in every 1mm increments of excavation. ABF QC Andrew Keech was observed performing Magnetic Particle Testing (MT) on the following various depths with one noted linear indication. This QA also performed the same test and noted same result. During the shift, the ABF personnel continued the excavation in 1mm increments using the same method of test and verification up to 33mm with same result. The shift was completed up to this depth of excavation.

The starting depth of excavation on this date was a continuation from the previous shift. The results of the exploratory excavations are as follows;

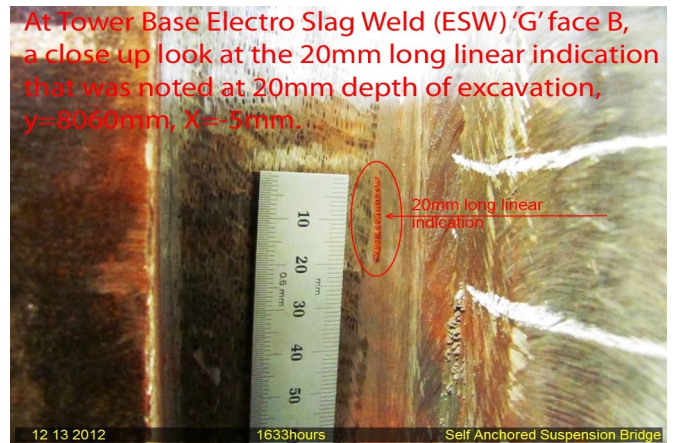
1. 19mm in depth – one 20mm long linear indication noted.
2. 20mm in depth – one 20mm long linear indication noted.

The exploratory excavations at this location will be continued on the following shift.

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At Tower Base Electro Slag Weld (ESW) 'V' weld joint #W-043 face B, ABF personnel was observed continuing to perform exploratory excavation on welded ESW at various Y locations; Y=1030mm, Y=1055mm, Y=1090mm, Y=1100mm and Y=1130mm due to UT detected defects. The ABF personnel have resumed the exploratory excavation at 63mm deep wherein ABF QC Jesse Cayabyab wants the width of the weld cover (35mm wide) to be the same width at the bottom of the excavation at 63mm. The width of the excavation at 63mm deep was originally measured at 25mm. The personnel were noted using only the disc grinder in widening the width of the excavation. At the end of the shift, widening of the excavation was still in progress and should remain tomorrow.



Summary of Conversations:

No significant conversation today.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

Inspected By: Lizardo, Joselito

Quality Assurance Inspector

Reviewed By: Reyes, Danny

QA Reviewer